

Work Order ID 72837

Tuesday, August 16, 2011 9:16:11 AM

Page 1

Item ID: D2842-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Assembly RH, 206 Float

Start Date: 8/16/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-14

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842
3-Deburr and bevel ends for welding

11-08-26

4

0

105

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

11-09-01

4x

110

0.00



Weld per dwg A/R Aluminum rod Batch 117884
Large Fab 114514

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs as per Dwg D2842
2-Grind end cap weld flush

11-08-06

11-09-13

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 ~~0~~ BE11/09/14

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulaluy

24
RM

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 ~~0~~ BE11-09-14

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H BL 11-9-15

160

Weld per dwg A/R Aluminum rod Batch: 114514 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

RH 11-09-15

4 6

170

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Memo

0.00

Quality Control

Sutor 116

x4
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, August 16, 2011 9:16:11 AM



Page 5

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Accept



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Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
210	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>118813.</u>								
220	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

4 BL 11-9-19

4. BL 11-9-19

PO 72837

S 11/9/20

x4
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

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Item Name: Step Assembly RH, 206 Float

Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P/P

0.00

Packaging

72833

11/9/20

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/20

MF
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, August 16, 2011 9:16:17 AM

Page 1

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

1. The first step is to identify the problem. This involves understanding the current situation and what needs to be changed.

2. The second step is to set goals. These should be specific, measurable, achievable, relevant, and time-bound (SMART).

3. The third step is to develop a plan. This involves identifying the resources needed and the steps to be taken.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves comparing the actual results with the goals and making adjustments as needed.

Required Date: 8/26/2011

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332 R	✓ Purchased	No	118354		100	Each	0.0000	3	12		BR 11-9-19	

1. The first step is to identify the problem. This involves understanding the current situation and what needs to be changed.

2. The second step is to set goals. These should be specific, measurable, achievable, relevant, and time-bound (SMART).

3. The third step is to develop a plan. This involves identifying the resources needed and the steps to be taken.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves comparing the actual results with the goals and identifying areas for improvement.

6. The sixth step is to adjust the plan. This involves making changes to the plan based on the evaluation results.

7. The seventh step is to communicate the results. This involves sharing the results with the relevant stakeholders.

8. The eighth step is to document the process. This involves recording the steps taken and the results achieved.

9. The ninth step is to review the process. This involves reflecting on the process and identifying lessons learned.

10. The tenth step is to improve the process. This involves making changes to the process based on the lessons learned.

D2622-120C

[illegible]

Step Extrusion


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	74	
64409	6	
<u>68293</u>	68	
WA	9.7	
46910	2	
66970	7.7	

[illegible]

Step End Plate

Manufactured	No
--------------	----

110	Each	45.0000	2
-----	------	---------	---

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA 	45	
70701	45	

[illegible]

Float Step Mounting Plate

Manufactured	No
1	1
2	1
3	1
4	1
5	1
6	1
7	1
8	1
9	1
10	1
11	1
12	1
13	1
14	1
15	1
16	1
17	1
18	1
19	1
20	1
21	1
22	1
23	1
24	1
25	1
26	1
27	1
28	1
29	1
30	1
31	1
32	1
33	1
34	1
35	1
36	1
37	1
38	1
39	1
40	1
41	1
42	1
43	1
44	1
45	1
46	1
47	1
48	1
49	1
50	1
51	1
52	1
53	1
54	1
55	1
56	1
57	1
58	1
59	1
60	1
61	1
62	1
63	1
64	1
65	1
66	1
67	1
68	1
69	1
70	1
71	1
72	1
73	1
74	1
75	1
76	1
77	1
78	1
79	1
80	1
81	1
82	1
83	1
84	1
85	1
86	1
87	1
88	1
89	1
90	1
91	1
92	1
93	1
94	1
95	1
96	1
97	1
98	1
99	1
100	1

110	Each	15.0000	2
-----	------	---------	---

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA017	15	
62955	15	

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, August 16, 2011 9:16:17 AM

Page 2

Work Order ID: 72837

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

D3459-3 Manufactured No

210 Each

21.0000

2

8



Float Step Mounting Plate

Location

Loc Qty

Loc Code

ST017

21

62956

21

8

MS27039C1-07 Purchased No

210 Each

53.0000

3

12



screw

Location

Loc Qty

Loc Code

ST293

53

117423 ✓

53

12

NAS1329C3KB130 Purchased No

210 Each

52.0000

3

12



insert

Location

Loc Qty

Loc Code

FP-A

2

115719

2

ST276

50

117679 ✓

50

12

NAS1515H3L Purchased No

210 Each

152.0000

3

12



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

112

113362

112

12

Tuesday, August 16, 2011 9:16:17 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

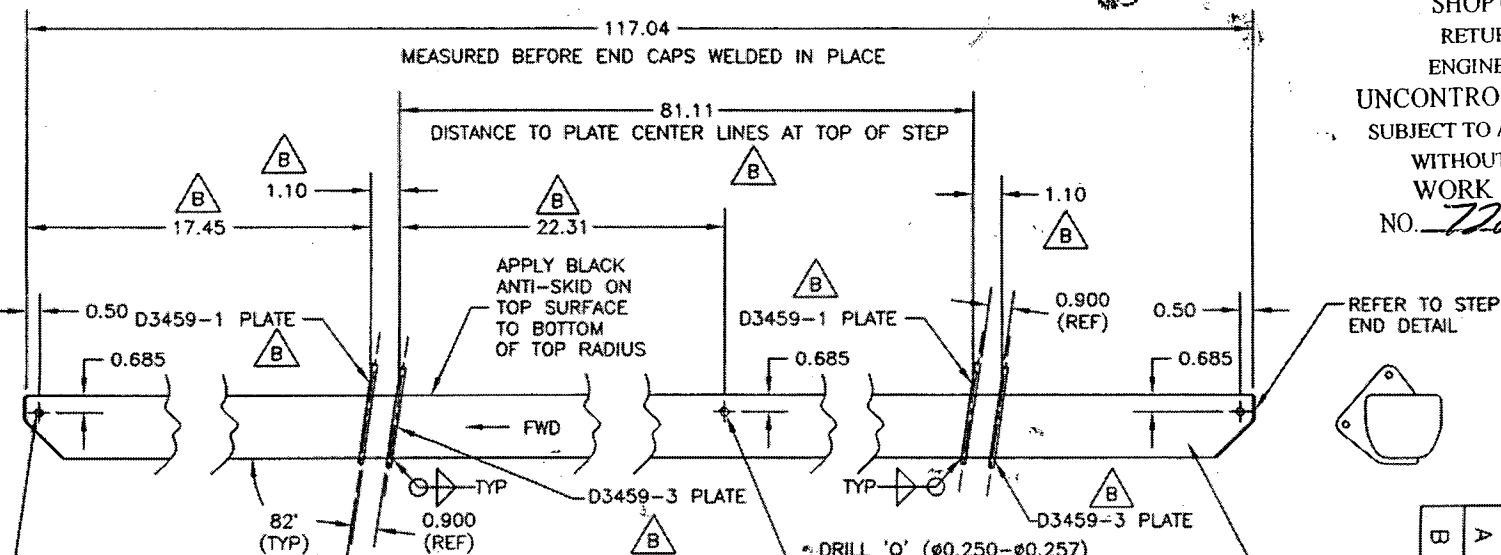
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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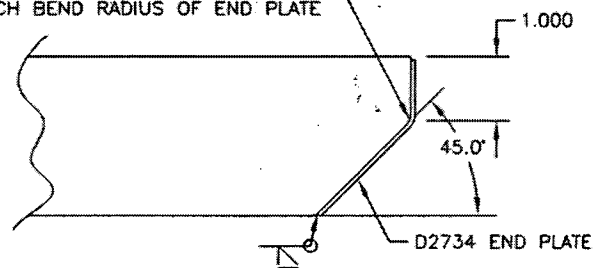
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMEND
WITHOUT NOTIC
WORK ORDER
NO. 72837

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE NTS
		SHEET 1 OF 1
		REV. B

RELEASED
8/14

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED